

Claims

1. A process for the manufacturing of a mattress comprising a bottom piece (1), longitudinal pieces (3), cross pieces (4) and a top piece (6),
5 **characterised in that** a liquid jointing substance (1,5) of the same material as the named pieces (1,3,4,6) is used in all the joints between the pieces.
2. A process according to claim 1,
characterised in that the pieces (1,3,4,6) comprise a foam
10 material which may be brought into a liquid state and subsequently hardened.
3. A process according to claim 2,
characterised in that the foam material is polyurethane.
4. A process according to any of the claims 1 to 3,
15 characterised in that it comprises the following steps, wherein:
 - (I) the bottom piece (1) is laid out;
 - (II) a moulding substance (2) is applied to the longitudinal edges (3) and cross edges (4) on one
20 surface side of the bottom piece (1);
 - (III) the longitudinal pieces (3) and cross pieces (4) are lowered into the moulding substance (2) and hardened;
 - (IV) the moulding substance (5) is applied on the same surface side of the bottom piece (1) between the longitudinal pieces (3) and cross pieces (4);
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 - (V) a core (5) is lowered into the moulding substance (5) and hardened; and

(VI) a top piece (7) is provided with moulding substance (5) and turned with the moulding substance (5) facing the named upright longitudinal pieces (3) and cross pieces (4) and lowered onto the same and hardened.

5 5. A process according to claim 4,
characterised in that in step II, the moulding substance (2) is applied to the under edges of the longitudinal pieces (3) and cross pieces (4) simultaneously or in any 10 order successively.

6. A process according to claim 4,
characterised in that in step IV, the moulding substance (2) is applied to the under side of the core (6).

15 7. A process according to any of the claims 4-6,
characterised in that the steps II and IV are performed simultaneously or in any order successively.

8. A process according to any of the claims 4-7,
characterised in that the steps III and V are performed simultaneously or in any order successively.

20 9. A process according to any of the claims 4-8,
characterised in that it further comprises a step wherein:

(VII) the moulding substance is injected into the corner joints between the longitudinal pieces (3) and cross pieces (4).

25 10. A process according to any of the claims 4-9,
characterised in that one or more steps are automated, such as by a robot.